

# Work Order ID 52330

Tuesday, September 22, 2009 3:12:24 PM



Page 1

Item ID: D2731-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

*RL*

Date:

*09-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2731

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Cut D2423 extrusion to .82"

Batch

*43722* *on 09/10/24*

*40* *Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D2731-7. □2-Check for crack while loading into the machine. □3-Tumble □4-Deburr any rough edges after tumbling

*on 09/10/30*

*40* *Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*on 09/10/30*






*40* *Ø*

# Work Order ID 52330



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Page 2

Item ID: D2731-7 Accept  Setup Start   
Revision ID: B Stop   
Item Name: Mounting Lug  
Start Date: 9/23/2009 Start Qty: 40.00  Cust Item ID:  
Required Date: 10/9/2009 Req'd Qty: 40.00  Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	M.A 09/10/30			40	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	BL 09-11-2			40			
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148 Memo START TIME: 12:00 3200 FINISH TIME: 12:30	0.00  0.00	BL 09-11-2			40			

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Item ID: D2731-7

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/11/09

140

170

Identify as per dwg &amp; Stock Location: 470

0.00



Packaging

Memo

0.00

Packaging

09/11/03 40

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/03 40

MF 09-11-03

# Picklist Print

Tuesday, September 22, 2009 3:12:23 PM

Page 1

Work Order ID: 52330



Parent Item: D2731-7RevB



Parent Item Name: Mounting Lug

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2731-7PRevB		Purchased	No			100	Each	0.0000	40.0000			
LUG												
D2423RevB1		Manufactured	No			110	f	684.6908	2.8758			
Lug Extrusion												

*A MF 09-11-03*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

684.69078

43722

213.01468

44529

22.39

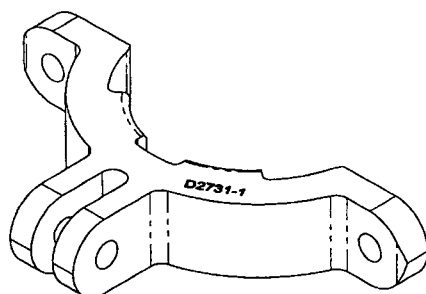
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449.2861

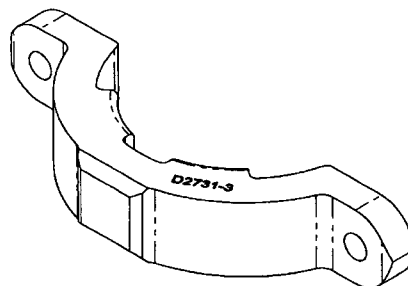
2.8758 *amt 09/10/24*



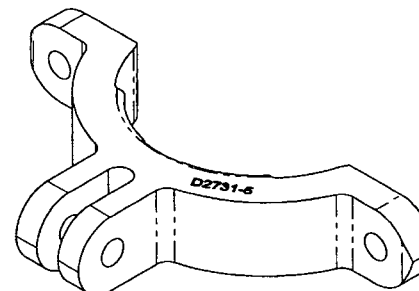
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 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 52330



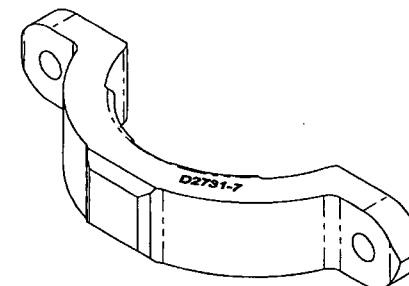
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

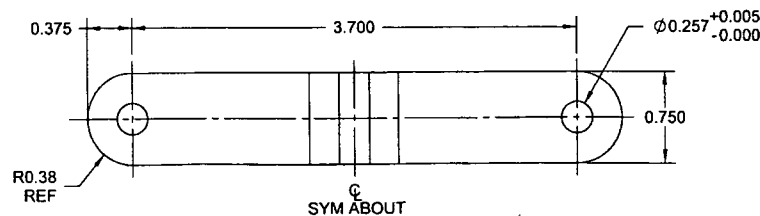
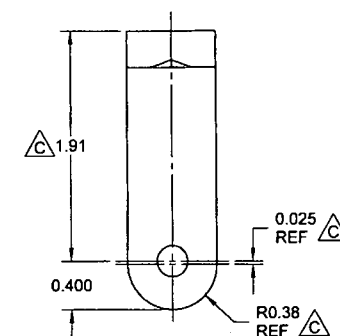
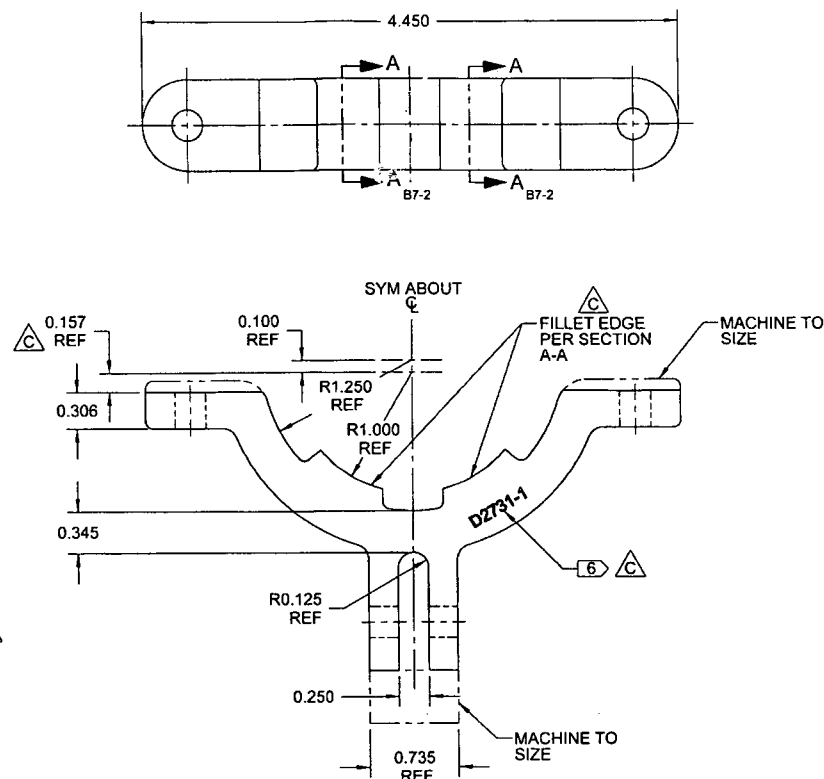
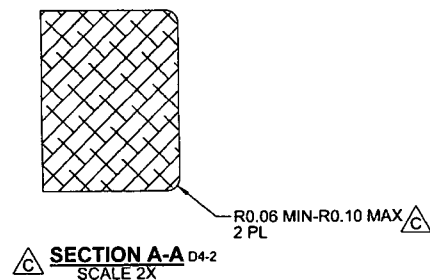
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 09/01/19

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS  
 OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs  
 -3: 0.15 lbs  
 -5: 0.16 lbs  
 -7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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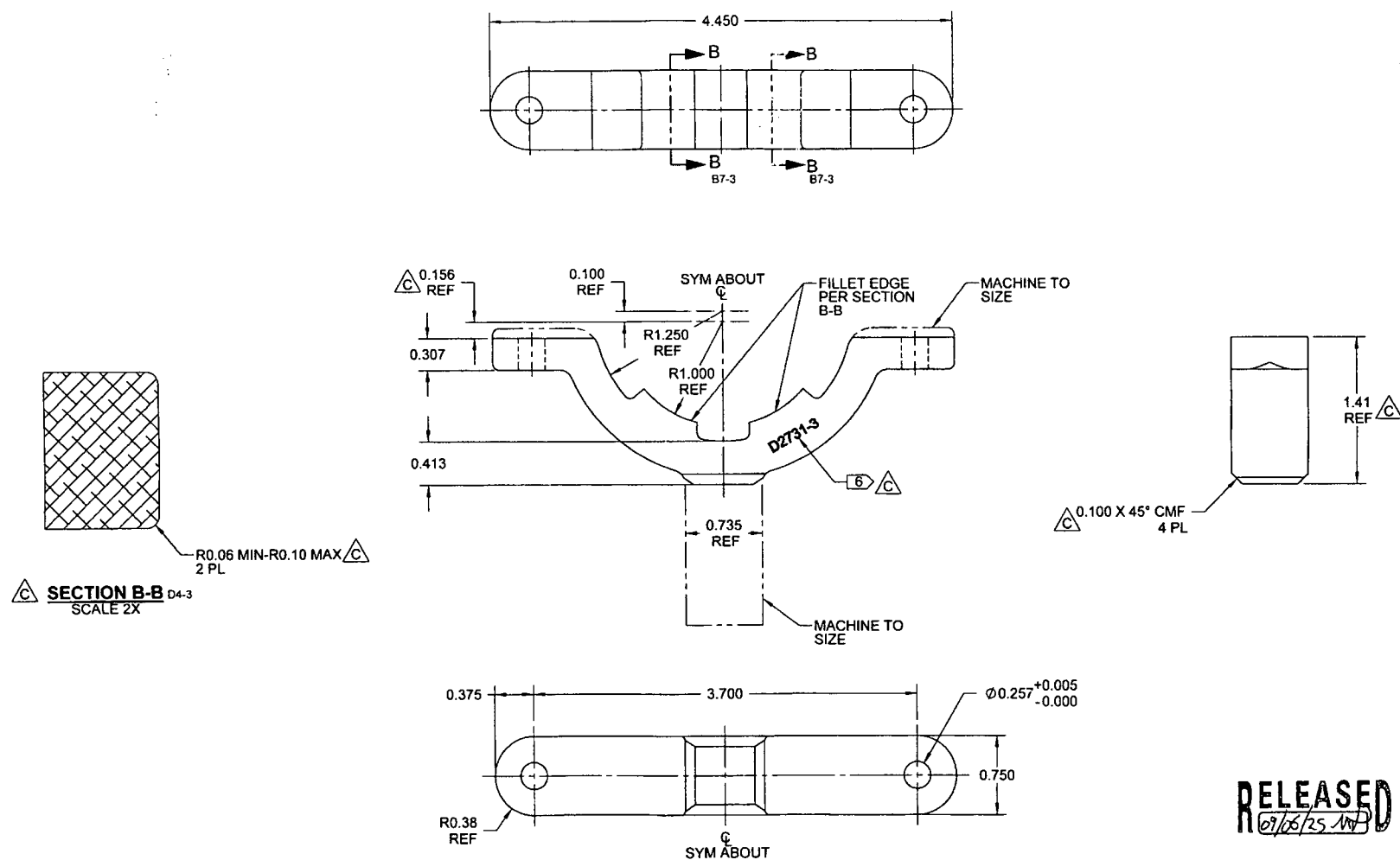


**D2731-1 MOUNTING LUG**

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**SECTION B-B** D4-3  
SCALE 2X

**D2731-3 MOUNTING LUG**

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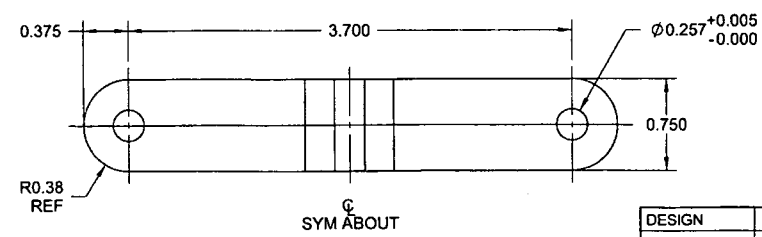
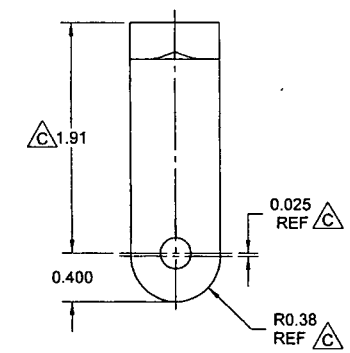
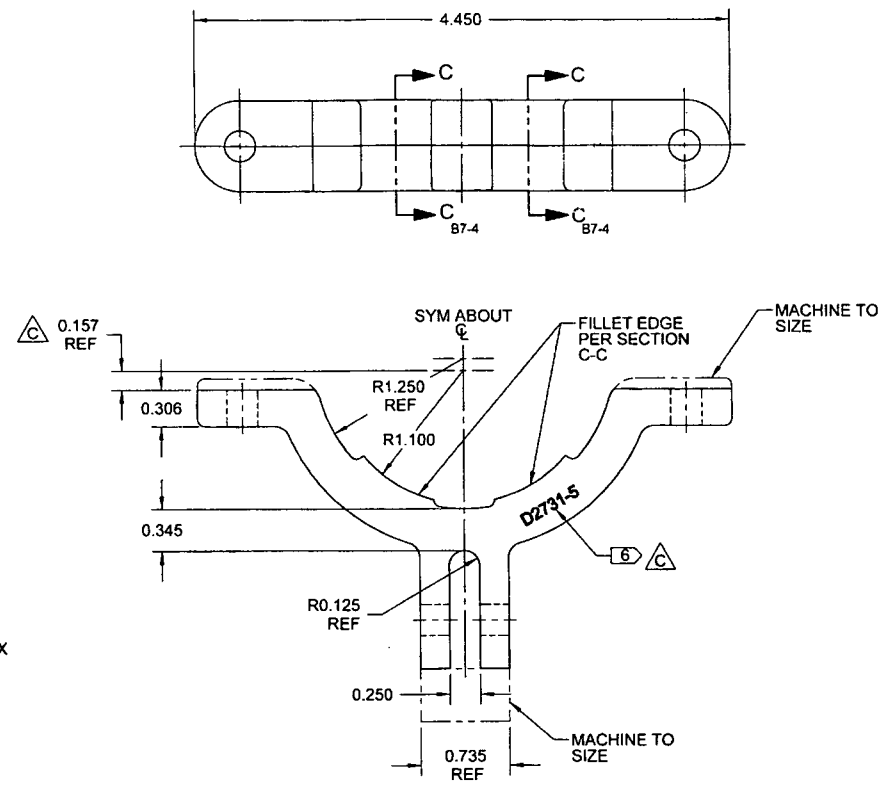
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SECTION C-C D4-4  
SCALE 2X

R0.06 MIN-R0.10 MAX  
2 PL

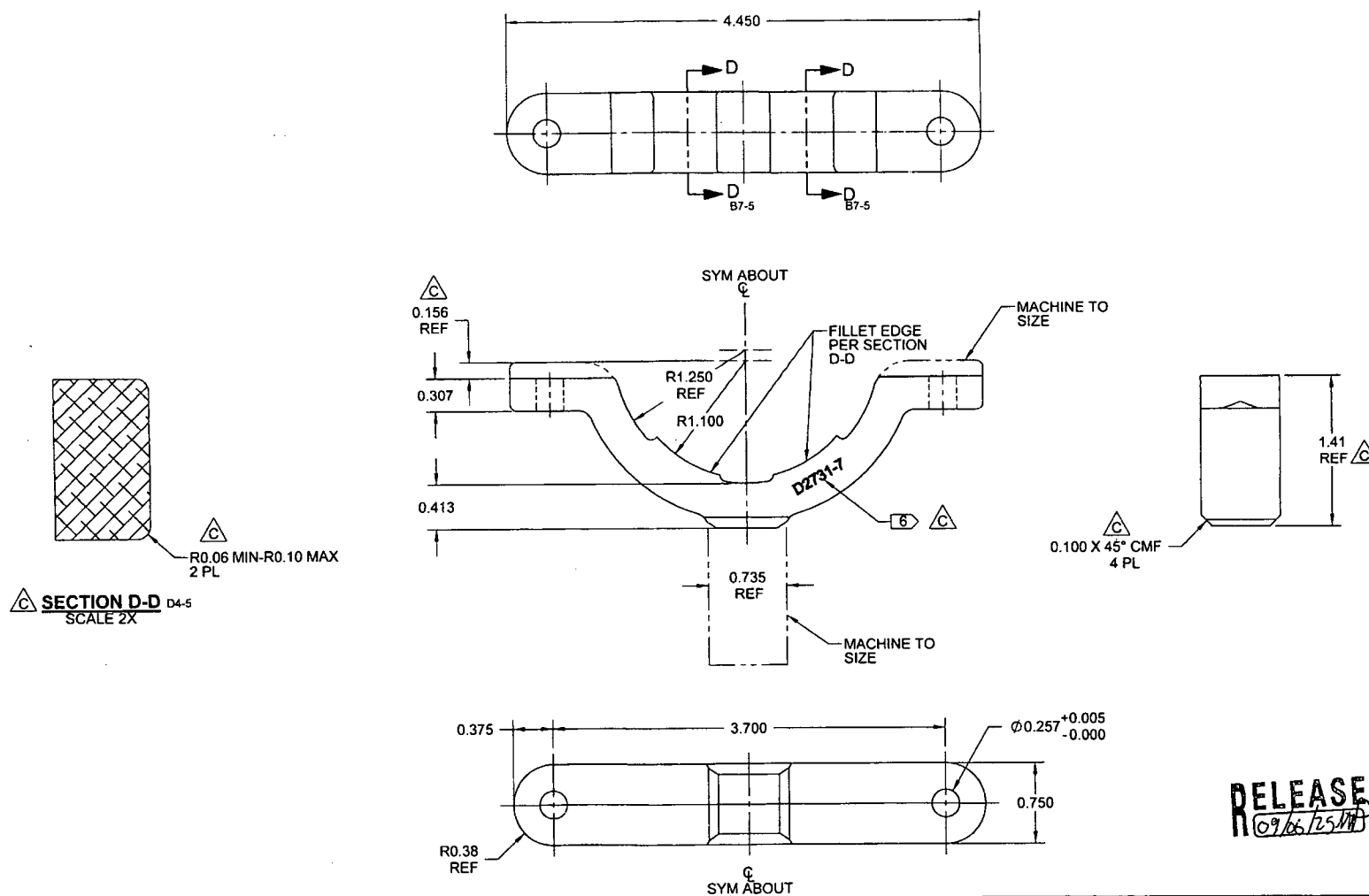


**D2731-5 MOUNTING LUG**





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9/6/75

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DE APPR.		MOUNTING LUG	NTS
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**D2731-7 MOUNTING LUG**

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